

Date: Wednesday, 5/23/2007 3:24:52 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 32477	
Estimate Number : 11169	
P.O. Number : <i>N/A</i>	Part Number : D32831
This Issue : 5/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3283 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 31942	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/10/2007 Qty: 60 Um: Each
Checked & Approved By : <i>[Signature]</i> 7.05.24	
Comment : Est A 04.09.28 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.2479 sf(s)/Unit Total : 14.8743 sf(s)  
6061-T6 .063 Sheet  
Material: 6061-T6 (QQ-A-250/11) 0.063" thick  
(M6061T6S.063)  
Identify for D3283-1  
Batch: *M15326*

2.0	SHEAR	SHEAR
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Comment: SHEAR  
Cut blanks: 15.550" x 1.540"

*SA 07.06.07* (60)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Machine as per Folio FA424 and Dwg D3283  
Stack of 10  
Identify as D3283-1

*SA 07.06.08* (60)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SA 07.06.08* (60)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SA 07.06.08* (x60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:24:52 PM  
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Drawing Name: DOUBLER

Job Number: 32477

Part Number: D32831

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



*[X] = Drill extra hole*



*(P70)*

Comment: SMALL & MEDIUM FAB RESOURCE 1 *As per Dwg*

Deburr *ml 07/06/17*

*(60)*

*SAD 07/06/18*

*60*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*En 07/06/18 (60)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *St 234*

*CP 07/06/18 (60)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



*(60)*

Comment: FINAL INSPECTION/W/O RELEASE

*FA 07/06/19*

Job Completion


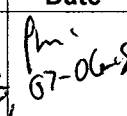
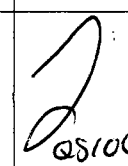
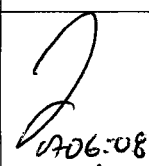


*L 07-06-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

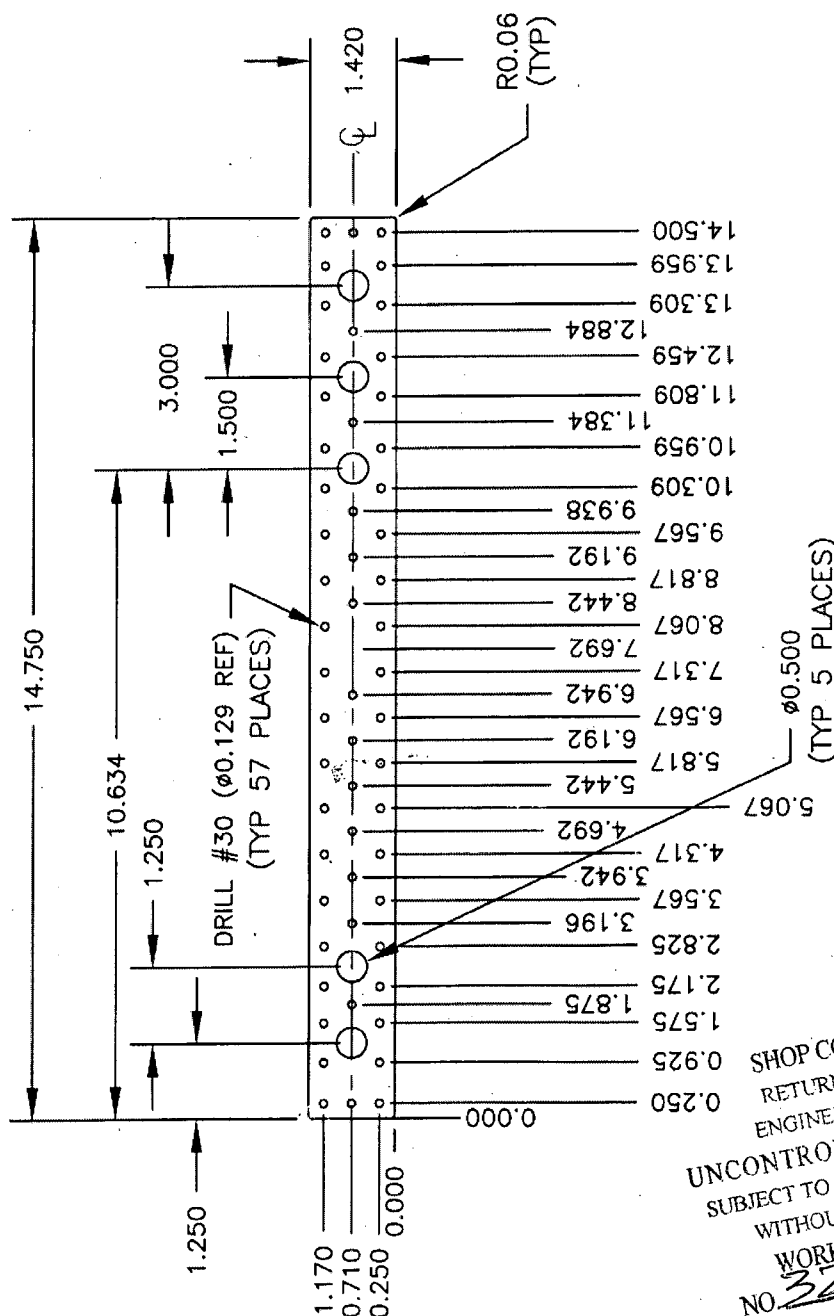
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-08	3.0 6.0	1 hole was missing on TRANS Program, to drill into the doublers, for a Qty of 10.	 QS1042	Program is fixed. Manually drill missing hole by placing the doublers offset, and transfer drill, deburr. drill @ sequence 6.0	 PM 07-06-08	Co 07/06/08	 QS1042	 0706-08

NOTE: Date & initial all entries

**DART**RELEASED  
05.09.06

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3283
				REV. D SHEET 1 OF 2
DATE	05.08.09	TITLE	DOUBLER	SCALE 1:3
A	04.05.06	NEW ISSUE		
B	04.08.09	10.882 WAS 11.502		
C	05.03.16	CHANGE HOLE PATTERN FOR -1		
D	05.08.09	REDESIGN		



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WORK ORDER  
NO. 32477

**D3283-1 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

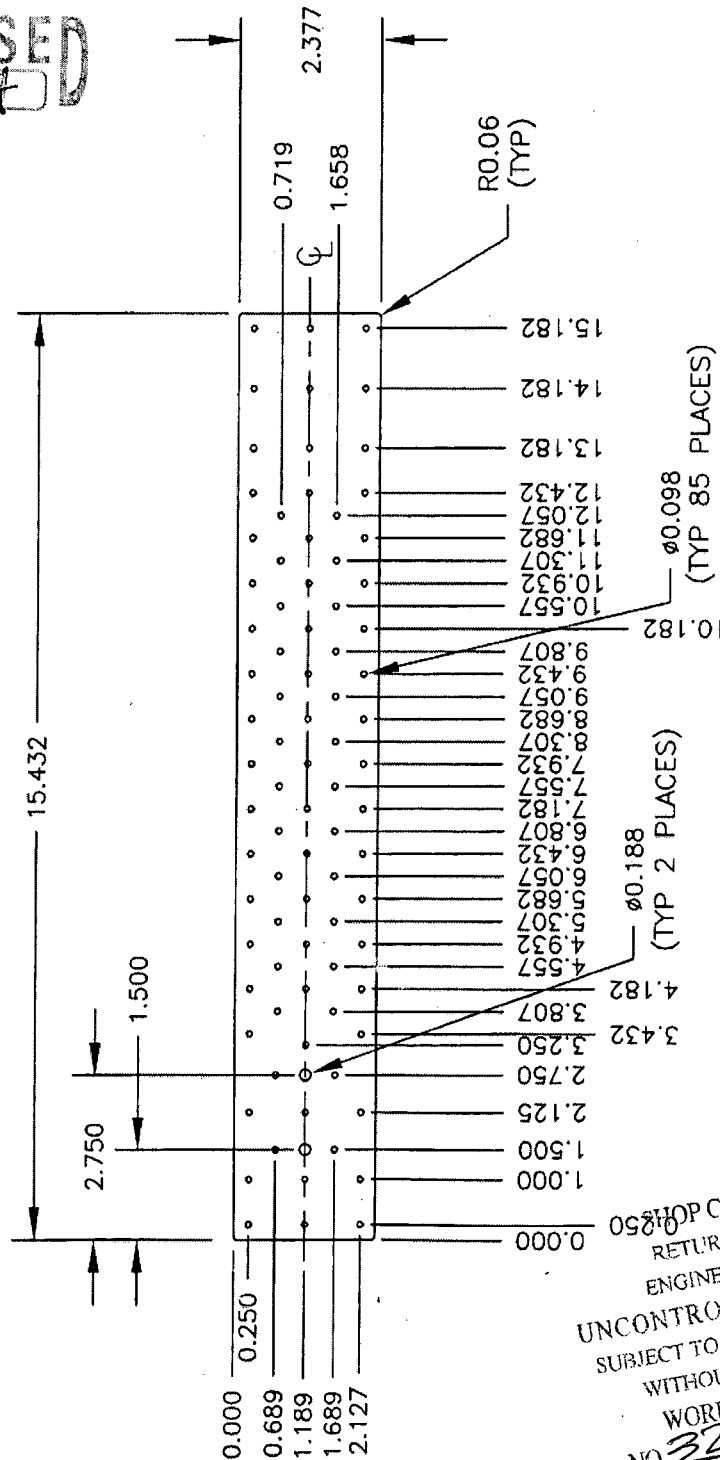
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3283	REV. D SHEET 2 OF 2
DATE 05.08.09		TITLE DOUBLER	SCALE 1:3

RELEASED  
05.09.06 *[Signature]*



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WITHOUT NOTICE  
WORK ORDER  
NO 32477

D3283-1-2 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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